

Date: Wednesday, 12/5/2007 8:02:24 AM  
User: Kim Johnston

## **Process Sheet**

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SUPPORT ASSEMBLY															
Job Number	36119																	
Estimate Number	10464																	
P.O. Number	N/A	Part Number	D3278041															
This Issue	12/5/2007	S.O. No.	N/A															
Prsht Rev.	NC	Drawing Number	D3278 REV.C															
First Issue	N/A	Project Number	N/A															
Previous Run	35593	Drawing Revision	C															
Written By	HJ 071205																	
Checked & Approved By																		
Comment	Est:A 04.04.19 New issue KJ/JLM EST B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM																	
<p style="text-align: right;">60 40 Qty: Um: Each</p> <h3>Additional Product</h3> <hr/> <p>Job Number: </p> <table border="1"> <thead> <tr> <th>Seq. #:</th> <th>Machine Or Operation:</th> <th>Description :</th> </tr> </thead> <tbody> <tr> <td>1.0</td> <td>-36119A- </td> <td>SUPPORT  ✓ B 36119 A(X 38) ml08/01/07 </td> </tr> <tr> <td>2.0</td> <td>-36119B- </td> <td>SUPPORT 29 35287 SP </td> </tr> <tr> <td>3.0</td> <td>D32783 </td> <td>Spacer SP 35593 B </td> </tr> <tr> <td>4.0</td> <td>MS20426AD36 </td> <td>Rivet SP 81/03 SO Box </td> </tr> </tbody> </table> <p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) Spacer Pick: Qty Part Number Description Batch 1 D3278-3 Spacer 135312 SP</p> <p>Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s) RIVET Pick: Qty Part Number Description Batch 4 MS20426AD3-6 Rivet 4105055 81/03 SO Box</p>				Seq. #:	Machine Or Operation:	Description :	1.0	-36119A- 	SUPPORT  ✓ B 36119 A(X 38) ml08/01/07 	2.0	-36119B- 	SUPPORT 29 35287 SP 	3.0	D32783 	Spacer SP 35593 B 	4.0	MS20426AD36 	Rivet SP 81/03 SO Box 
Seq. #:	Machine Or Operation:	Description :																
1.0	-36119A- 	SUPPORT  ✓ B 36119 A(X 38) ml08/01/07 																
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3.0	D32783 	Spacer SP 35593 B 																
4.0	MS20426AD36 	Rivet SP 81/03 SO Box 																

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 8:02:24 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 36119

Part Number: D3278041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



X60

Comment: SMALL & MEDIUM FAB RESOURCE 1

Rivet spacers with support as per Dwg D3278.

ml 08/01/07

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

✓ 08/01/07 (6)

7.0 D22301

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Mounting Lug

120.

Pick: Packing Kit

Qty Part Number      Description      Batch

2 D2230-1 Mounting Lug

D36102 (100)

08/01/08  
D 33250 (20)

8.0 AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number      Description      Batch

2 AN4-13A Bolt

106242 91

106-513 93

SP

9.0 AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number      Description      Batch

4 AN960JD416 Washer

M105906

50

10.0 MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number      Description      Batch

2 MS21042L4 Nut

M10505Y

8/1/03 SCP (60X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: LD Date: 08/01/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 8:02:24 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 36119

Part Number: D3278041

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble support as per Dwg D3278.

\*\*\*DO NOT TIGHTEN BOLTS\*\*\*

Identify as D3278-041

*8/08/08 (60)*

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*cooks 8/08/08 (60)*

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*8/1/08 SG 68X (60)*

14.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Da8/01/08*

Job Completion



*ini 2008/1/08*

*U*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

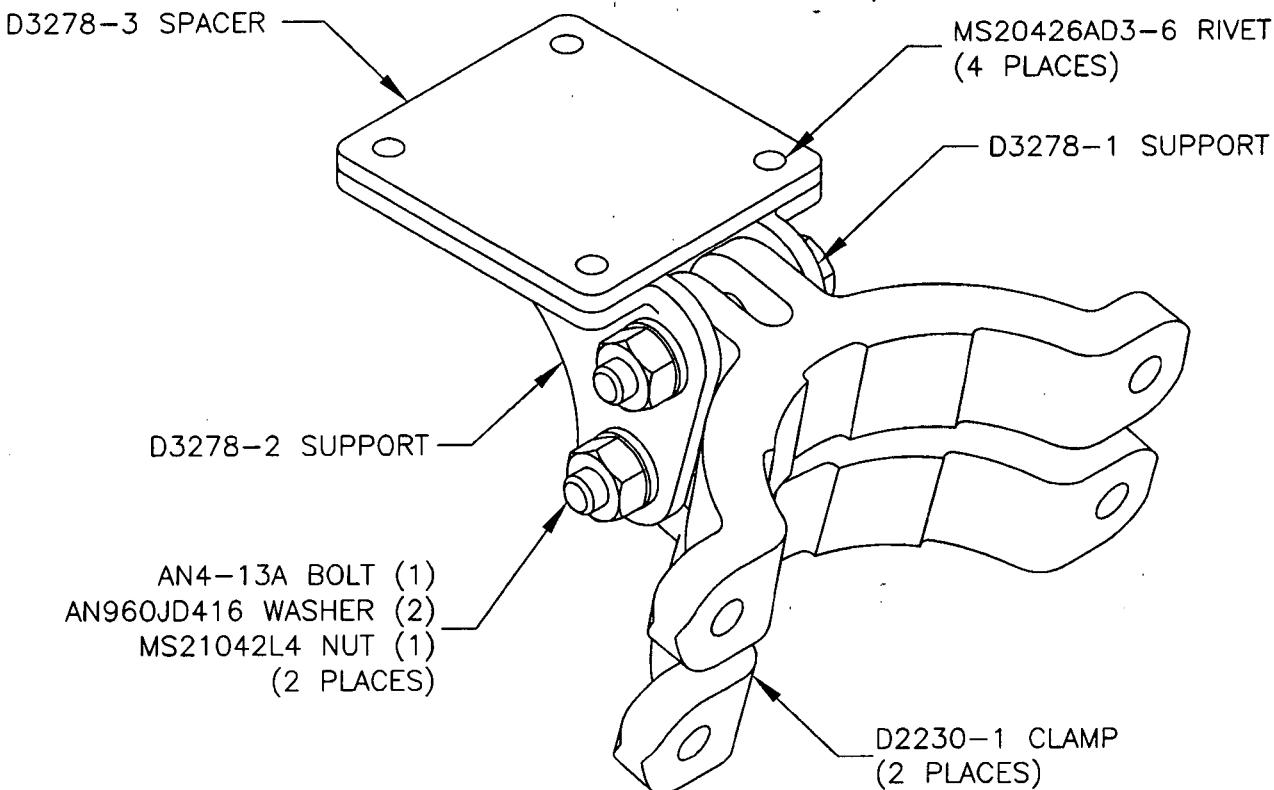
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>91</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278
DATE 07.07.24		TITLE SUPPORT ASSEMBLY
		SCALE NTS
A	04.03.03	NEW ISSUE
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT
C	07.07.24	CHANGED RIVETS PER PAR #185

**RELEASED**  
*07.08.08*D3278-041 SUPPORT ASSEMBLY

Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

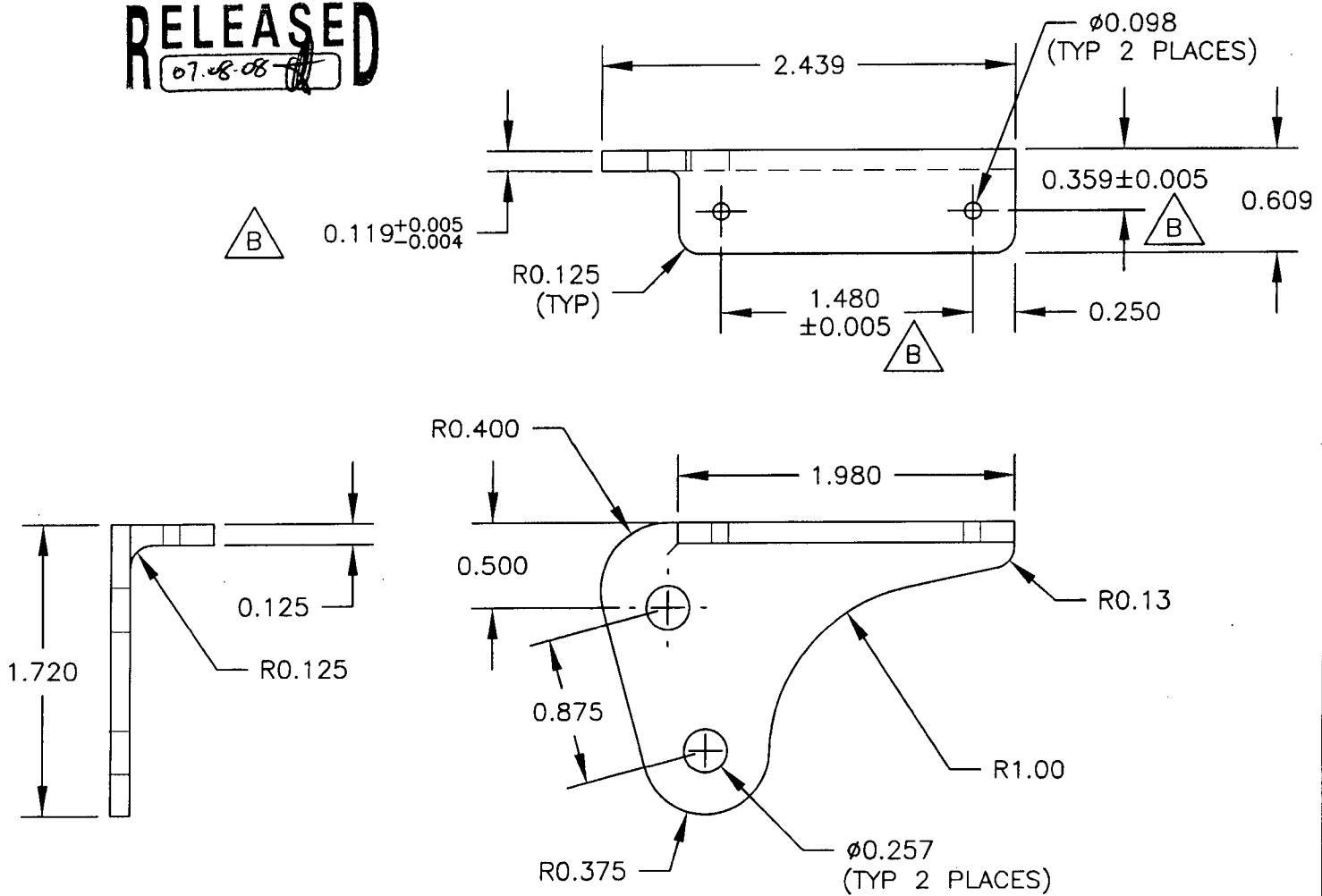
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WITHOUT NOTICE  
WORK ORDER  
NO. *36119*

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**DART**

DESIGN <i>GP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

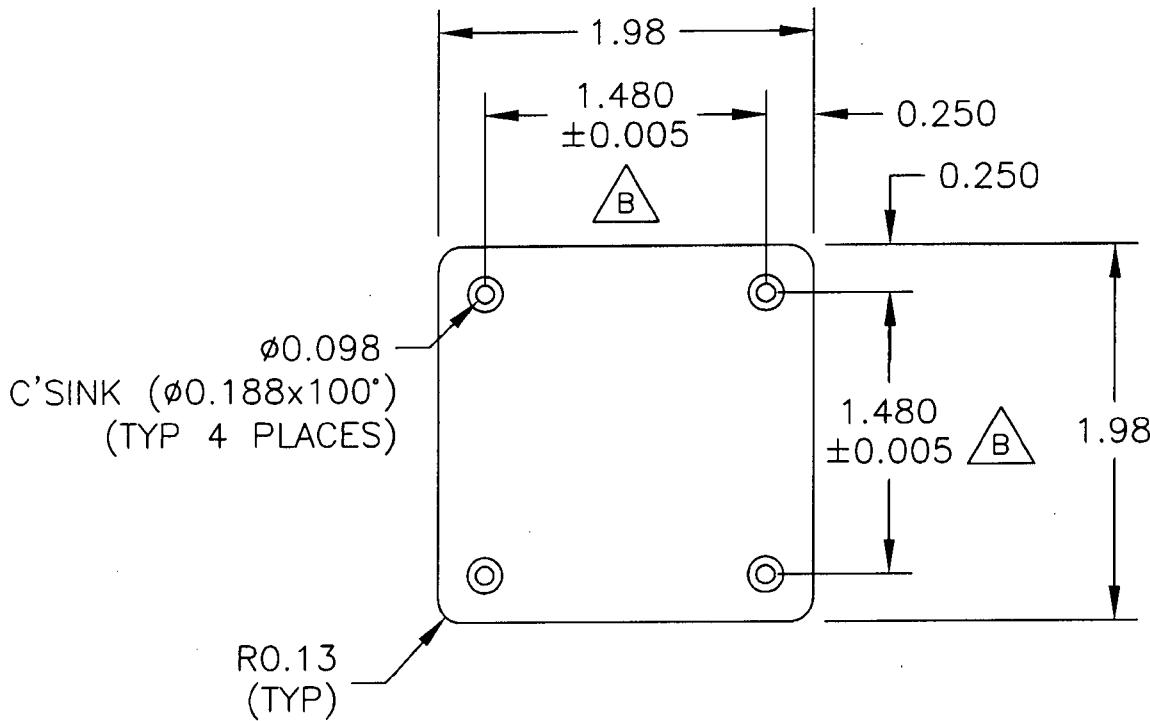
**RELEASED**  
07-08-08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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**DART**

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**  
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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